Monday, 10/16/2006 2:01:47 PM Kim Johnston User: **Process Sheet** : SPACER **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer : 29015 Job Number **Estimate Number** : 10692 : D32863 : NIK **Part Number** P.O. Number : D3286 REV A S.O. No. : 411A **Drawing Number** : 10/16/2006 This Issue : N/A **Project Number** Prsht Rev. : MA : MACHINED PARTS First Issue Type **Drawing Revision** : 24711 Material **Previous Run Due Date** : 10/27/2006 Qtv: 20 Um: Each Written By Checked & Approved By New issue KJ/JLM Comment **Additional Product** Job Number: **Machine Or Operation: Description:** Seq. #: M304TR0500W049 304 RD Tube .500 x .049W 1.0 Comment: Qty.: 0.3588 f(s)/Unit Total: 7.1757 f(s) 304 RD Tube .500 x .049W Turn (2) D3286-3 per (1) skidtube assemblyDwg D3286 Material: AISI 304/316 SS tubing 0.500" OD x 0.049" wall (M304TR0.500W.049) Identify as D3286-3 HARDINGE CNC LATHE SMALL HARDINGE 2.0 Comment: HARDINGE CNC LATHE SMALL Turn blanks as per Folio FA434 and Dwg D3286 INSPECT PARTS AS THEY COME OFF MACHINE QC2 3.0 20 Comment: INSPECT PARTS AS THEY COME OFF MACHINE QC8 SECOND CHECK 4.0 Comment: SECOND CHECK 70 SMALL & MEDIUM FAB RESOURCE 1 SMALL FAB

Comment: SMALL & MEDIUM FAB RESOURCE 1

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mF. 06/10/26

Dart Ae	rospace L	_td							
W /O:			V	ORK ORDER CH	IANGES				
DATE	STEP	PROCEDURE CHANGE				Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Car	tegory:	NCF	R: Yes N	DQA:	Date: _	36/11/01
						QA: N/C	Closed:	Date: _	
NCR:		V	ORK OR	DER NON-CONFO	DRMANCE	(NCR)			
		Description of NC		Corrective Action	Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descrip	Action Description Chief Eng		Section C	Chief Eng	QC Inspector
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NCR:		WORK ORDER NON-CONFORMANCE (NCK)									
		Description of NC		Corrective Action Section B				A			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspecto			
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NOTE: Date & initial all entries

Monday, 10/16/2006 2:01:47 PM Date: Kim Johnston User: **Process Sheet Drawing Name: SPACER** Customer: CU-DAR001 Dart Helicopters Services Job Number: 29015 Part Number: D32863 Job Number: Description: Seq. #: **Machine Or Operation:** INSPECT WORK TO CURRENT STEP 6.0 QC5 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 7.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: FINAL INSPECTION/W/O RELEASE 8.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion C Loco 111101

Dart Ae	rospace	Ltd									
W/O:			WO	RK ORDER CHANGES							
DATE	STEP	PRO	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No		PAR #:	Fault Categ	jory: N	ICR: Yes	No DQ	A:	Date: _			
					QA: N	/C Close	d:	_ Date: _			
NCR:			WORK ORDE	R NON-CONFORMAN	CE (NCR	2)					
		Description of NC	Corrective Action Section B			Verific		Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		Section C			Chief Eng	QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29015
Description: Spacer	Part Number:	D3286-3
Inspection Dwg: D3286 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

		Prot	otype		
Drawing	Tolerance	Actual	Accept	Reject	Method

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.000	+/-0.010	4,001	_ســ			
0.500	+/-0.010	, 497				
.049	ナ.010	,049	-			
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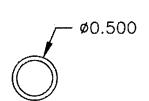
Measured by:	A -	Audited by: 5D	Prototype Approval:	N/A
Date:	06/10/18	Date: 06.10.18	Date:	N/A

Rev	Date	Change	Revised by	Approv <i>e</i> d
Α	04.09.01	New Issue	KJ/JLM of	
				7,4. /



DESIGN	DRAWN BY	DART	AEROSPACE PORT HADLOCK, V	
CHECKED,	APPROVED	DRAWING NO.		REV. A
#-	1 1	D3286	•	SHEET 2 OF 2
DATE		TITLE		SCALE
04.05.06		GROUND I	HANDLING PARTS	1:1

-		 2	1.00) 		<u>.</u>	-



D3286-3 SPACER

- 1) MATERIAL: AISI 304/316 SS TUBING, 0.500 O.D. x 0.049 WALL (REF DART SPEC. M304TR0.500W.049)

 2) BREAK ALL SHARP EDGES 0.010 TO 0.020

 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 4) ALL DIMENSIONS ARE IN INCHES



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